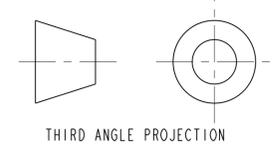
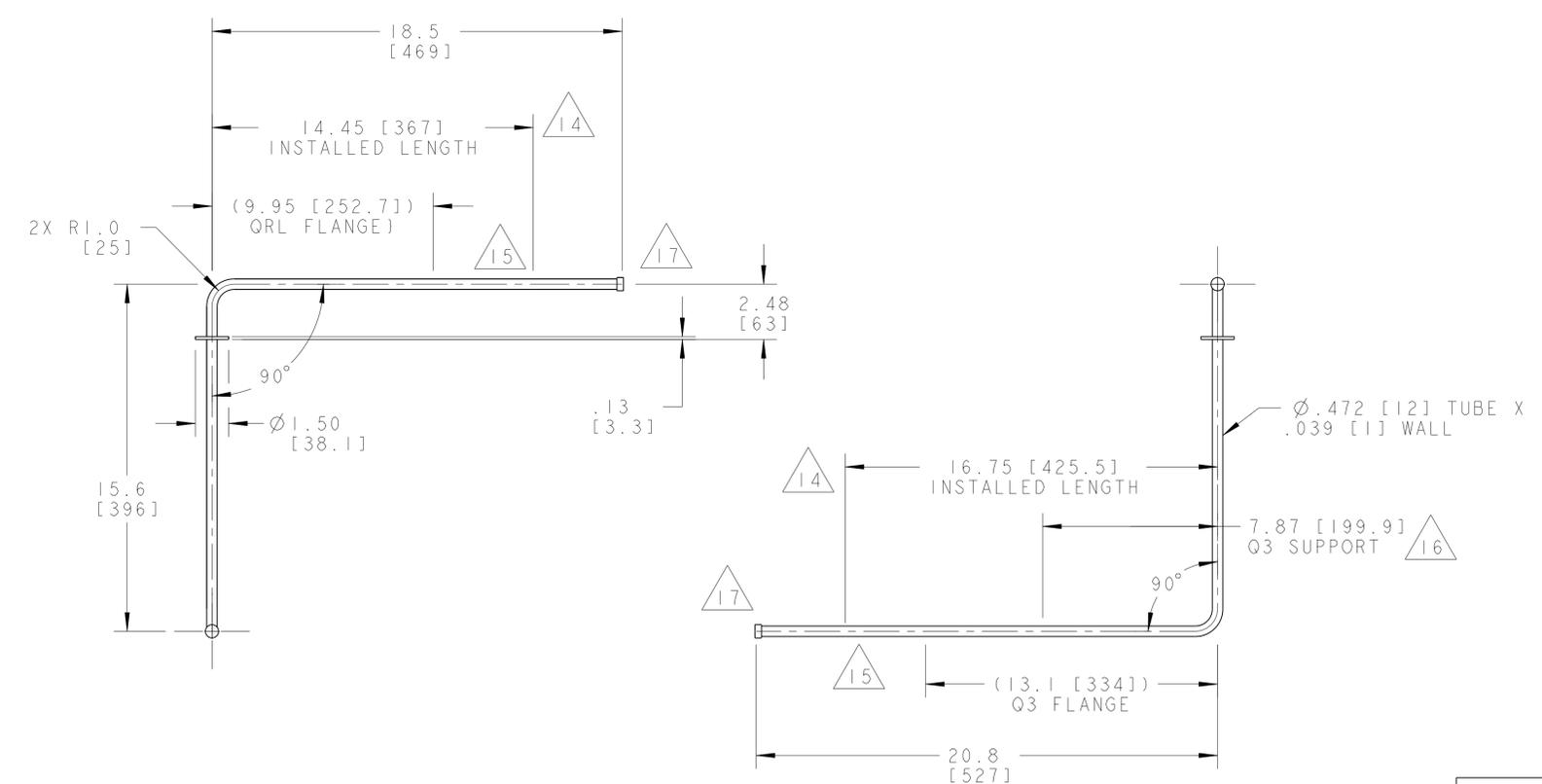
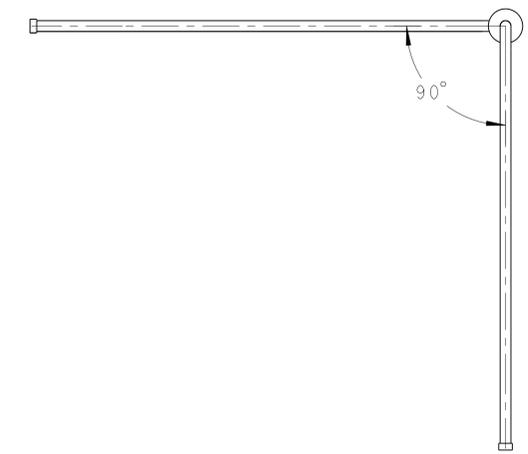
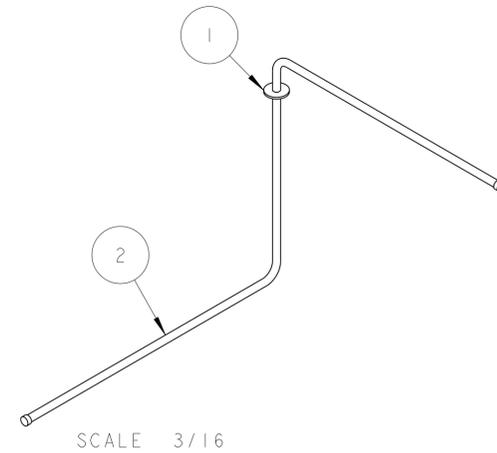


DWG. NO.		SIZE		REV.	SH.
2515534		B		1	
2	-	1	TUBE, PER ASTM A269		SS 304L
1	-	1	COLLAR		SS 304L
ITEM	PART NO	REQD	DESCRIPTION		MATERIAL

NOTES: (UNLESS OTHERWISE SPECIFIED)

- THIS IS A CRYOGENIC VACUUM COMPONENT.
- WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
- USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
- USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
- VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
- FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
- VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
- REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
- TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
- PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989. (B)
- A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF ±0.063".
- PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
- PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT. (B)
- CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS. (B)



REV	DWG	CHK	ZONE	DATE	CHANGES
B	ARH	SPV		01/15/03	REVISED DRAWING NOTES 13, 16 & 17, MINOR DRAWING DIMENSIONAL CHANGES
A	ARH	SPV		11-01-02	INITIAL RELEASE

UNLESS OTHERWISE SPECIFIED		SHOP ORDERS		SER. NO.	-
X.X ± 0.1	FRAC. ± 1/64	ACCT. NO.	NO.	DATE	ISSD
X.XX ± 0.03	Angles ± 1.00°	DEL. TO	NO.	DATE	REQD
X.XXX ± 0.010	FINISH 125 \sqrt{Ra}	SURFACE TREATMT			
DO NOT SCALE PRINT		IDENT. METHOD			
THREADS ARE CLASS 2		PROJECT TAG			
CHAMFER ENDS OF ALL SCREW TRENDS 30°		PROJECT NUMBER			
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREADS		PROJECT NAME			
BREAK EDGES .016 MAX. ON MACHINED WORK		DATE		16-Apr-02	
REMOVE BURRS, WELD SPLATTER & LOOSE SCALE		DATE		01-Nov-02	
IN ACCORDANCE WITH ANSI Y14.5M & B46.1		DATE		08-AUG-02	

ERNEST ORLANDO LAWRENCE
BERKELEY NATIONAL LABORATORY
 UNIVERSITY OF CALIFORNIA - BERKELEY

LHC IR FEEDBOX
 CRYOGENICS
 PIPE, CY1

MICROFILMED:	DWG. TYPE	SHOWN ON	SCALE: 1/4	DO NOT SCALE PRINTS
	ASSEM	-		
PATENT CLEAR:	DESIGN ACCT. NO.	CATEGORY CODE	DWG. NO.	SIZE
	Z5LCE2	LH2003	2515534	REV. B

SHEET 1 OF 1